

Date: Tuesday, 4/4/2006 1:27:08 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 26489
 Estimate Number : 10495
 P.O. Number : N/A
 This Issue : 4/4/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 26443
 Drawing Name : LITTER TIE DOWN ASS'Y (LOCKING)
 Part Number : D2360
 Drawing Number : D2360 / D2341
 Project Number : N/A
 Drawing Revision : C1 / E
 Material : N/A
 Due Date : 4/24/2006 Qty: 4 Um: Each
 Written By : *See comment below*
 Checked & Approved By : *06.04.04*
 Comment :

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6201 T Extrusion 4X4X3/8



Comment: Qty.: 1.1067 f(s)/Unit Total: 4.4268 f(s)
 Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion)
 Batch: *526538*

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks: 12.65" Long

SD 06.05.06

4

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio D2341 and Dwg D2341

SD 06.05.07

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 06.05.07

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SD 06.05.08 4

6.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Deburr and Tumble



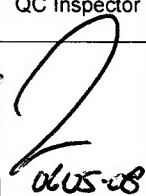
SD 06.05.07

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|---|--|-----------------------------------|--|-----------------------|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 06.05.07 | 6 | During assembly 2 parts stuck together and caused damage on the edge of on part .020" deep in 2 locations. See photo's. |  | Fill damaged areas with weld, and grind flush to dwg dimensions. AS per QS1 004. | SD 06.03.08 f.k. 06.05.8 |  060508 | 8 May 06 |  060508 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:27:08 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING)

Job Number: 26489

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



06-05-08 (4)

Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M 06/05/09 (4)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.M 06-05-16 (4)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

D2002015

Knob



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Knob

Batch B16177B

12.0

D2345

Lock Channel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Lock Channel

B26457

13.0

D2366

Lock Handle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Inventory

B19288

14.0

D2367

Handle Knob



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Inventory

B26597

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING)

Job Number: 26489

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Quick Release

B26497(8) ~~B26502(1)~~

16.0

D2373

Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Spring

B19508(3) B26458(1)

17.0

D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pip Pin Assembly

B25824

18.0

AN526C1032R18

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw

M14523

19.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer

M18235 M100743

20.0

AN960JD10L

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)
Washer

M18235

21.0

MS20470AD34

Rivet,Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Rivet,Universal Head

M15541

22.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)
Nut

M18917

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING)

Job Number: 26489

Part Number: D2360

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw

M13719

24.0

MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Screw

M15432

25.0

NAS679A3W

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut

M1463

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D2360

SAD 06:05:18

(4)

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-05-18 (4)

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 50 171

06-05-19 (4)

29.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion



06-05-23

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



| | | | |
|----------------------|-------------------------|--|------------------------|
| DESIGN <i>BW</i> | DRAWN BY <i>BW</i> | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>D108</i> | DRAWING NO. D2360 | REV. C SHEET 1 OF 2 |
| DATE 97.08.27 | | TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) | |
| A | 95.02.10 | NEW ISSUE | |
| B | 95.02.20 | RE-DESIGN | |
| C | 97.08.27 | ADD MS20470AD3-4 RIVET | |
| <i>C1</i> | <i>02.09.24</i> | <i>D2002-015 WAS D2376</i> | |

RELEASED
97 08 27 BW

| D2360 | Part No. | Description |
|----------|------------------|------------------------------------|
| X | D2360 | LITTER TIE DOWN ASSEMBLY (LOCKING) |
| | | |
| | | |
| | | |
| 1 | D2341 | LITTER TIE DOWN (LOCKING) |
| 1 | D2345 | LOCK CHANNEL |
| 2 | D2366 | LOCK HANDLE |
| 1 | D2367 | KNOB (DELTRIN) |
| 2 | D2372 | QUICK RELEASE FASTENERS |
| 1 | D2373 | SPRING |
| 2 | D2376 | KNOB (DELTRIN) <i>D2002-015</i> |
| 1 | D2444 | PIP PIN |
| | | |
| | | |
| 1 | AN526C1032R18 | SCREW |
| <i>2</i> | AN960JD10 | WASHER |
| <i>3</i> | AN960JD10L | WASHER |
| 1 | MS20470AD3-4 | RIVET |
| 3 | MS21042L3 | NUT |
| 1 | MS27039-1-13 | SCREW |
| 2 | MS27039-1-15 | SCREW |
| 1 | NAS679A3W | NUT |

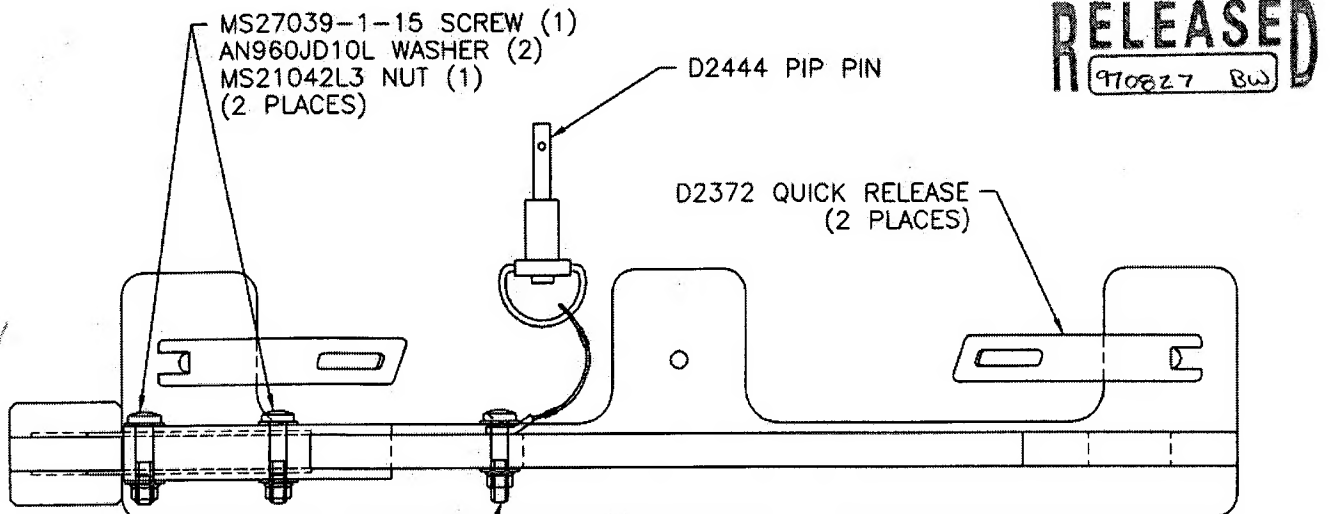
KE 99.03.02

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WORK ORDER
NO. *26489*

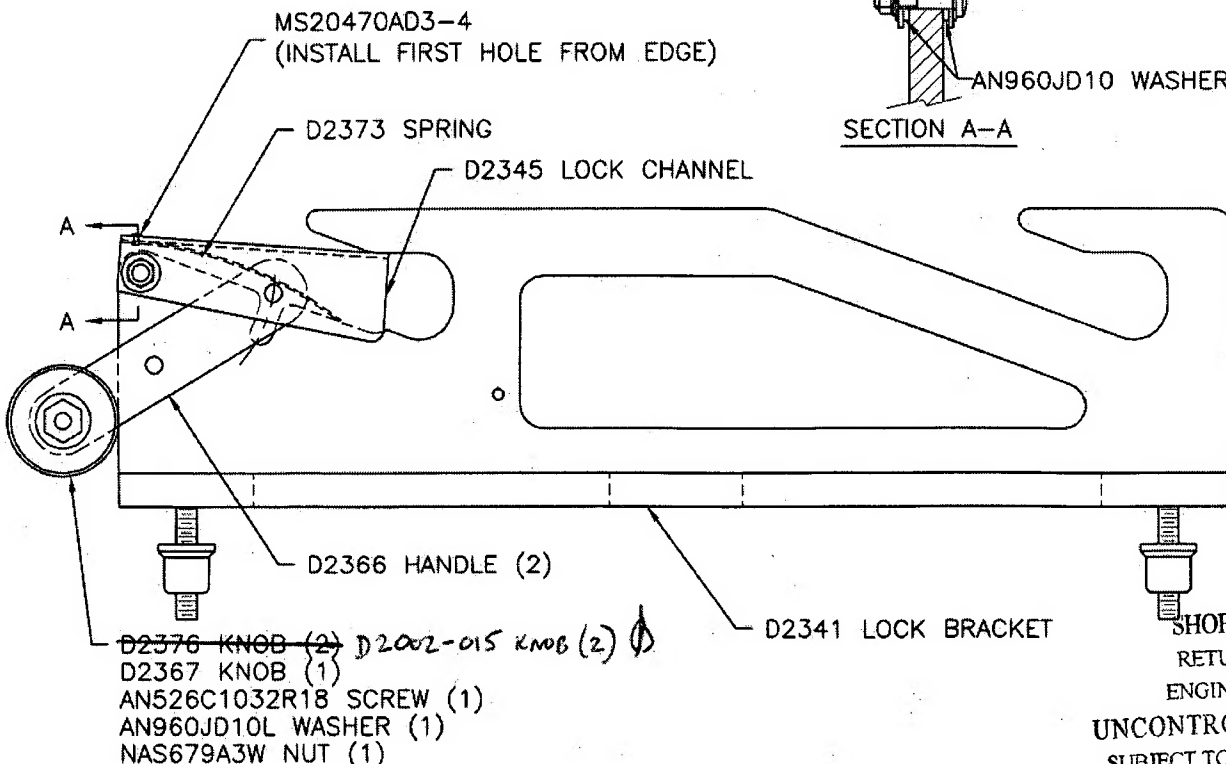
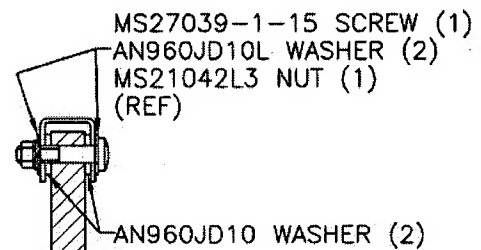


| | | | |
|----------------------|-----------------------|--|------------------------|
| DESIGN <i>BW</i> | DRAWN BY <i>BW</i> | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED <i>LE</i> | APPROVED <i>MB</i> | DRAWING NO. D2360 | REV. C SHEET 2 OF 2 |
| DATE 97.08.27 | | TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) | |

RELEASED
970827 BW



MS27039-1-13 SCREW
AN960JD10LWASH (3) *LE 99.07.02*
MS21042L3 NUT

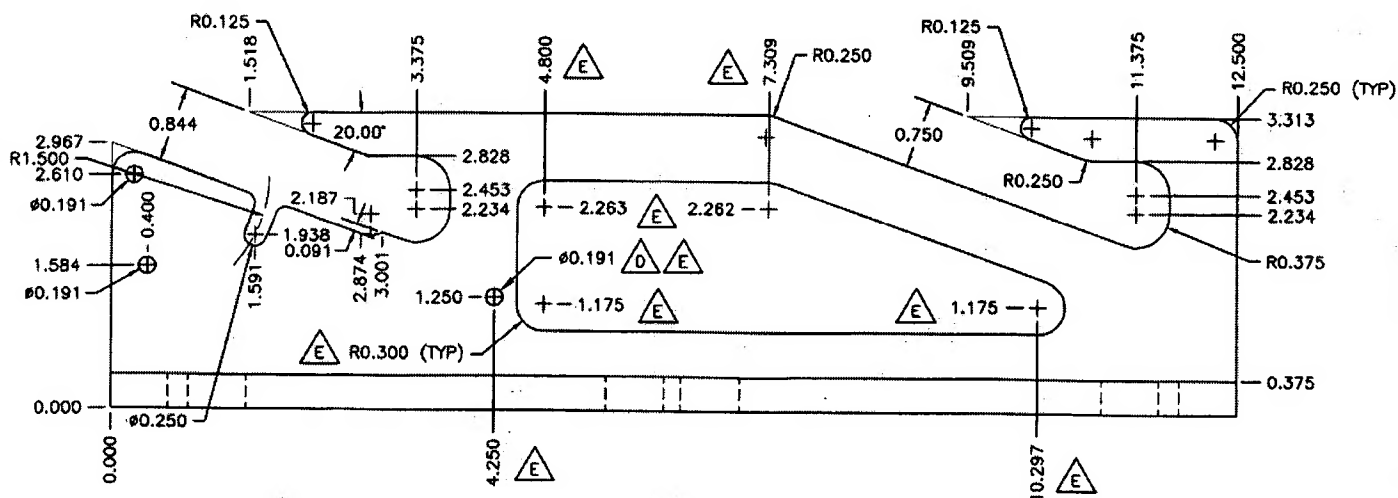
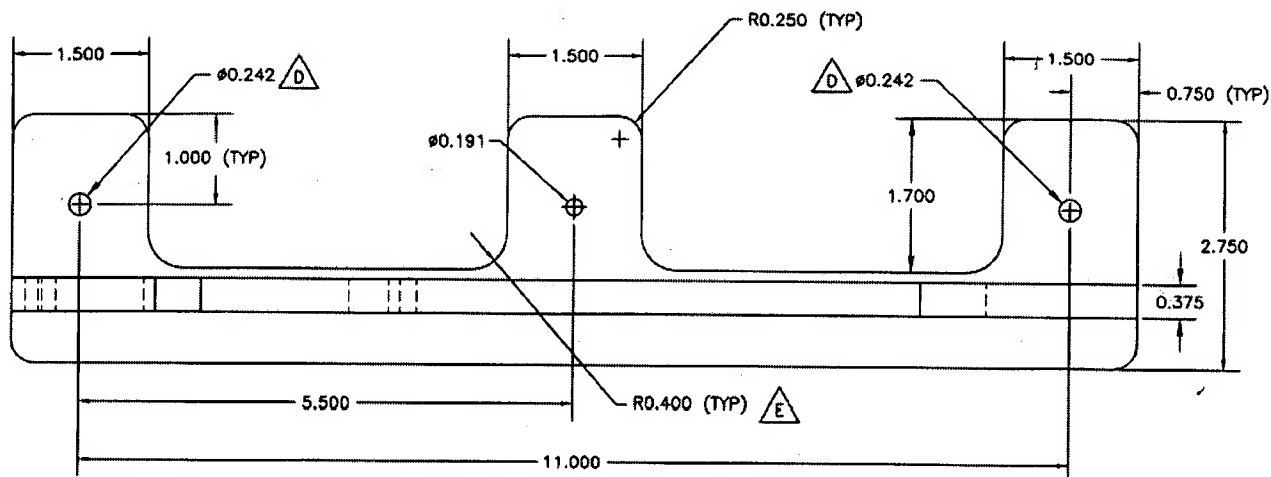


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| DESIGN BW | DRAWN BY KE | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED mm | APPROVED BW | DRAWING NO. D2341 | REV. E SHEET 1 OF 1 |
| DATE 97.10.01 | | TITLE LITTER TIE DOWN BRACKET (LOCKING) | SCALE 1:2 |
| A | 95.01.13 | NEW ISSUE | |
| B | 95.02:14 | MODIFIED LOCK | |
| D | 95.02:20 | CHANGES TO DIAMETERS | |
| E | 97.10.01 | CHANGES FOR MACHINING | |

RELEASED
971003 KE
TSR A130



MATERIAL: 6061-T6 (QQ-A-200/8) 4X4X3/8 'T' SECTION
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WITHOUT NOTICE
WORK ORDER
NO. 26489

Work Order: 26489
 Part Number: D2341-1
 Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article ☐ Prototype ☐

| Part Number | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------|-----------|------------------|--------|--------|----------------------|----------|
| 1.500 | | 1.502 | / | | | |
| 1.000 | | 1.005 | / | | | |
| Ø.242 | | Ø.242 | / | | | |
| Ø.191 | | Ø.191 | / | | | |
| R.250 | | R.250 | / | | | |
| 1.700 | | 1.698 | / | | | |
| .750 | | .754 | / | | | |
| 2.750 | | 2.756 | / | | | |
| 11.000 | | 10.996 | / | | | |
| 5.500 | | 5.501 | / | | | |
| 1.584 | | 1.586 | / | | | |
| Ø.191 | | Ø.191 | / | | | |
| 2.610 | | 2.612 | / | | | |
| .844 | | .842 | / | | | |
| 1.250 | | 1.2495 | / | | | |
| .750 | | .752 | / | | | |
| 12.500 | | 12.502 | / | | | |
| 3.313 | | 3.314 | / | | | |
| 4.250 | | 4.250 | / | | | |
| .400 | | .400 | / | | | |

SN
 06.05.07

Audited by: S.G.
 Date: 06/05/08

Prototype Approval: N/A
 Date: N/A

Revised by: Approved
 KJ/RF

